

Work Order ID 79531

79531

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January-26-12 4:31:19 PM

Item ID: D2755-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug
 Start Date: 26/01/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 09/02/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 12/01/27 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2755	Rev B								
100		0.00							
100	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut D2762 extrusion to 3.100" +0.015"/-0.000								
110		0.00							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine per folio H2755-1 and drawing D2755Deburr								
120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

SL 13-01-06

10

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PTO

SL

10

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DAS 25 13-01-07

SL

10

φ

DAS 25 13-01-07

W/O: 79531		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2755-1 PAR #: _____ Fault Category: Machining / LOA NCR: Yes No DQA: OK Date: 2013/01/23
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: OK Date: 11

NCR: 13-2236		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
13/01/07	110	4 parts are scrap, middle hole is off tolerance in center and dimension 2.541 is also off	DAS 16 8-83 Q52042 13/01/07	scrap + replace at 74 <u>B 8324</u>	SL 13/01/07	W	DAS 16 8-83 Q52042 13/01/07	DAS 16 8-83 13/01/07
		- parts were not correctly placed in jig R.L. operator error	AS 16 8-83 Q52042 13/01/24	45.64 x 4 182.56			AS 16 8-83 Q52042 13/01/24	

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

10

Cust Item ID:

10

Customer:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

160

Memo

0.00

Quality Control

Identify as per dwg & Stock Location: 31 479

0.00

170

Packaging

Memo

0.00

Packaging

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

2013-01-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 79531

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Parent Item: D2755-1

D2755-1

Parent Item Name: Lug

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C02.04.04Re-formatNG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2762-108		Manufactured	No			100	Each	115.2800	0.2583	2.718947			

D2762-108

Extrusion

**

SL 130106

Location

Loc Qty

Loc Code

Mezz

115.28

7479

26.78

8324

88.5

2.72

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 79531
Description: Aft Bracket		Part Number: D2755-1
Inspection Dwg: D2755	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.000	+/-0.010	2.996	/		vern	SL-10
2.000	+/-0.010	2.000	/			
0.187	+/-0.010	.180	/			
R0.500	+/-0.010	.500	/			
0.250	+/-0.010	.243	/			stock
R0.625	+/-0.010	.625	/			
0.50	+/-0.030	.498	/			
0.500	+/-0.010	.500	/			
1.500	+/-0.010	1.503	/		46	
Ø0.257	+0.006/-0.001	.258	/			
R0.500	+/-0.010	.500	/			
3.000	+/-0.010	3.001	/			
2.000	+/-0.010	2.000	/			
0.50	+/-0.030	.500	/			

Measured by: SL
Date: 13-01-07

Audited by: DAS BA 08
Date: 15/01/08

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.15	New Issue	KJ	

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



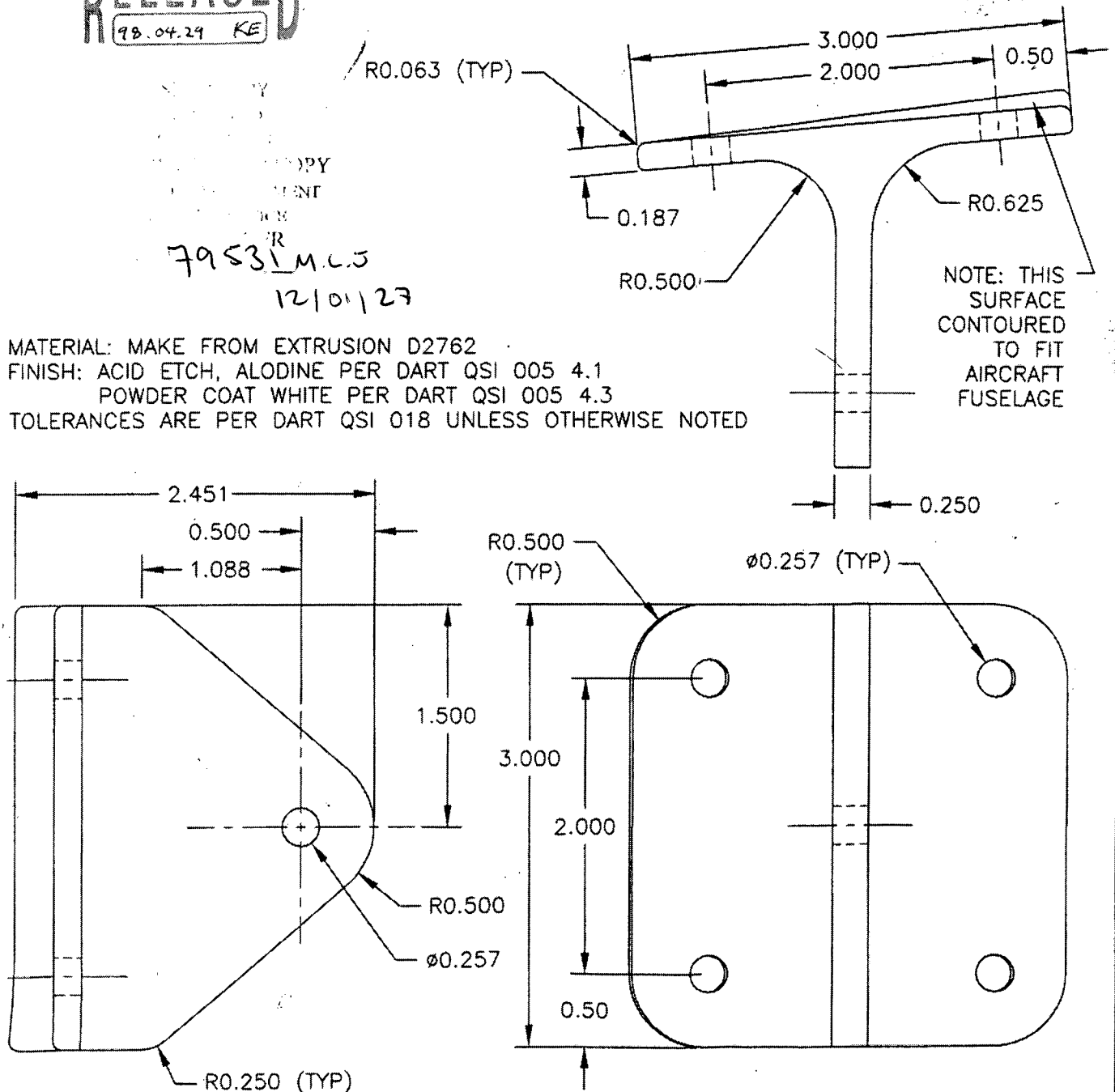
DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2755	REV. B SHEET 1 OF 1
DATE 98.04.29		TITLE AFT BRACKET	SCALE 1:1
A	98.04.01	NEW ISSUE	
B	98.04.29	ADDED -1 AND -2 IDENTIFICATION	

RELEASED
98.04.29 KE

79531 M.C.S

12/01/23

MATERIAL: MAKE FROM EXTRUSION D2762
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2755-1 LH AFT BRACKET (SHOWN)
D2755-2 RH AFT BRACKET (OPPOSITE)

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25672

8662